



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G19731-3G
Job Sheet 174606



Part No: RBW6305G19731-3G

Job Qty: 1 ea

Part Name: Main Rotor Drive Tool 2 (Box 2 Of 2)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/20/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G19731-3G Rev A IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Small Fab-4		30
110	Small Fab	1 pcs	11/12/18	11/12/18	0.00	1.00	Small Fab-4		AP 9-89
120	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC4		38
130	Packaging	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-1		9-89
140	QC21-FG	1 Ea	11/12/18	11/12/18	0.00	0.00	QC21		21 DEC 12 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1610-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6305G19731-3G-27 and RBW6305G19731-3G-29 to RBW6305G19731-3G-25 foam. 6-Glue foam to case and pack
case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5021040
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab	5113449
APP-1610-E	Case	1 Ea (1 ea)	110-Small Fab	5060679
RBW6305G14631-3G	Tail Rotor Drive Quill Seal Housing Remover	1 Ea (1 ea)	110-Small Fab	5065045
RBW6305G14831-3G	Tail Rotor Drive Quill Lip Seal Remover	1 Ea (1 ea)	110-Small Fab	5067423
RBW6305G15731-3G	Tail Rotor Drive Quill Seal Installer	1 Ea (1 ea)	110-Small Fab	5067421
RBW6305G16031-3G	Drive Quill Seal Housing Remover	1 Ea (1 ea)	110-Small Fab	5065878
RBW6305G16231-3G	Fan/Ecs Drive Quill Lip Seal Installer	1 Ea (1 ea)	110-Small Fab	5067082
RBW6305G16831-3G	Fan Drive Quill Lip Seal Remover	1 Ea (1 ea)	110-Small Fab	5061201
RBW6305G18331-3G	Ecs Drill Quill Lip Seal Remover	1 Ea (1 ea)	110-Small Fab	5065081
RBW6305G18631-3G	Ecs Drive Quill Housing Remover	1 Ea (1 ea)	110-Small Fab	5065484
RBW6305G19151-3G	Guide Fan Drive Quill Seal Housing Installer	1 Ea (1 ea)	110-Small Fab	5061487
RBW6305G19231-3G	Puller Rotor Brake Adapter Flange Remover	1 Ea (1 ea)	110-Small Fab	5065502
RBW6305G19731-3G-23	Bottom Foam	1 Ea (1 ea)	110-Small Fab	5060681
RBW6305G19731-3G-25	Top Foam	1 Ea (1 ea)	110-Small Fab	5060683
RBW6305G19731-3G-27	Inside Placard	1 Ea (1 ea)	110-Small Fab	5061441
RBW6305G19731-3G-29	Tool Layout Placard	1 Ea (1 ea)	110-Small Fab	5061450

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB41011	1	709	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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110-Small Fab

97524A032	4	723	0
APP-1610-E	1	7	0
RBW6305G14631-3G	1	3	0
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RBW6305G15731-3G	1	3	0
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RBW6305G19151-3G	1	3	0
RBW6305G19231-3G	1	3	0
RBW6305G19731-3G-23	1	2	0
RBW6305G19731-3G-25	1	2	0
RBW6305G19731-3G-27	1	2	0
RBW6305G19731-3G-29	1	2	0

Part Specifications

Specifications could not be found.

Plex 11/6/18 1:31 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S137258



Part: RBW6305G19731-3G

Job No: 174606

Serial No/Batch: S137258

Revision: A

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/12/18

DQA: _____ Date: _____



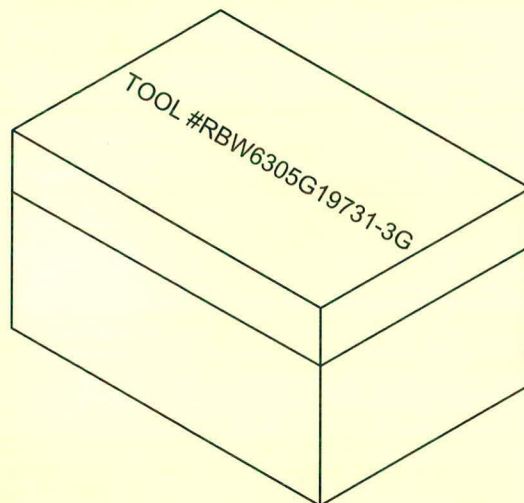
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -1, -17, -19, -21, -25, -27 BOM INFO, ADDED -29 PER R.W. CH'D -23 FOAM DIM'S, CH'D Ø4.02 DEPTH FROM 2.50 PER R.W. CH'D -25 FOAM DIM'S, CH'D CUTOUT TO RECESS FOR -27 & -29 PER R.W. ADDED TOOL NUMBER & ITEM NUMBER COLUMN -27 PER R.W.	3/24/11	RJC	RW
1A	CH'D -23 Ø4.02 HOLE DEPTH FROM Ø3.50 & CORRECTED SIDE VIEW PER D.W. CH'D Ø3.84 HOLE DEPTH FROM 7.75 & Ø4.69 HOL DEPTH FROM 3.00 TO FIT BETTER.	9/16/11	RJC	DW
1B	CH'D TITLE WAS "MAIN ROTOR DRIVE SEAL REPLACEMENT TOOL KIT" IS "MAIN ROTOR DRIVE TOOL KIT 2". CH'D -1 THRU -19 BOM DESCRIPTION TO MATCH PARTS MANUAL. -27 CH'D TOOL No. -27 & -29 CH'D FROM B/O TO MANUFACTURED.	10/31/13	CFS	RJC
1C	ADDED -33 & -35 TO BOM. -27 CH'D ITEM NUMBERS WAS 9-18 IS 1-10.	5/30/14	DPD	RJC

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	GUIDE, FAN DRIVE QUILL SEAL HOUSING INSTALLER		RBW6305G19151-3G	2
			-3	1	TOOL, FAN/ECS DRIVE QUILL LIP SEAL INSTALLER		RBW6305G16231-3G	2
			-5	1	PULLER, ROTOR BRAKE ADAPTER FLANGE REMOVER		RBW6305G19231-3G	2
			-7	1	TOOL, ECS DRIVE QUILL SEAL HOUSING REMOVER		RBW6305G18631-3G	2
			-9	1	TOOL, ECS DRIVE QUILL LIP SEAL REMOVER		RBW6305G18331-3G	2
			-11	1	TOOL, DRIVE QUILL SEAL HOUSING REMOVER		RBW6305G16031-3G	2
			-13	1	TOOL, T/R DRIVE QUILL LIP SEAL REMOVER		RBW6305G14831-3G	2
			-15	1	TOOL, T/R DRIVE QUILL SEAL HOUSING REMOVER		RBW6305G14631-3G	2
			-17	1	TOOL, T/R DRIVE QUILL LIP SEAL INSTALLER		RBW6305G15731-3G	2
			-19	1	TOOL, FAN DRIVE QUILL LIP SEAL REMOVER		RBW6305G16831-3G	2
	B/O	-21	1	CASE		PLASTIC	22 x 17 x 9-3/4 PELICAN #APP-1610-E	N/S
	B/O	-23	1	BOTTOM FOAM		Y20 BLACK	8.43 x 17.12 x 22.21 I.R. SPECIALTY FOAM	3
	B/O	-25	1	TOP FOAM		C200 FLAT BLACK	2.04 x 17.12 x 22.21 I.R. SPECIALTY FOAM	4
		-27	1	INSIDE PLACARD		PLASTIC	1/16 x 6-1/2 x 6-3/4	5
		-29	1	TOOL LAYOUT PLACARD		PLASTIC	1/16 x 6-1/2 x 8-3/4	6
	B/O	-31	1	RB PLACARD		ALUMINUM	RB41009 PLACARD	N/S
	B/O	-33	4	RIVET		ALUMINUM	Ø1/8 X 3/8 MCMMASTER-CARR #97447A130	N/S
	B/O	-35	4	WASHER		ALUMINUM	Ø1/8 MCMMASTER-CARR #90183A213	N/S

NOTE:

1. ALSO SOLD WITH KIT RBW6305G01531-3G, BOX TWO OF TWO.

 RED BARN MACHINE

TITLE

MAIN ROTOR DRIVE TOOL KIT 2

DWG NO.

RBW6305G19731-3G

REV
1C

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS .XXX ± .005
FRACTIONS ± 1/32
ANGLES ± 5°
METRIC REF.
XXmm ± .1mm
FRACTIONS ± 1/32
ANGLES ± 5°

DRAWN BY: CLOUGH

APPROVED

HEAT

TREAT

FINISH

SPEC

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

USED ON MODEL

AW139

SCALE

1:16

DATE

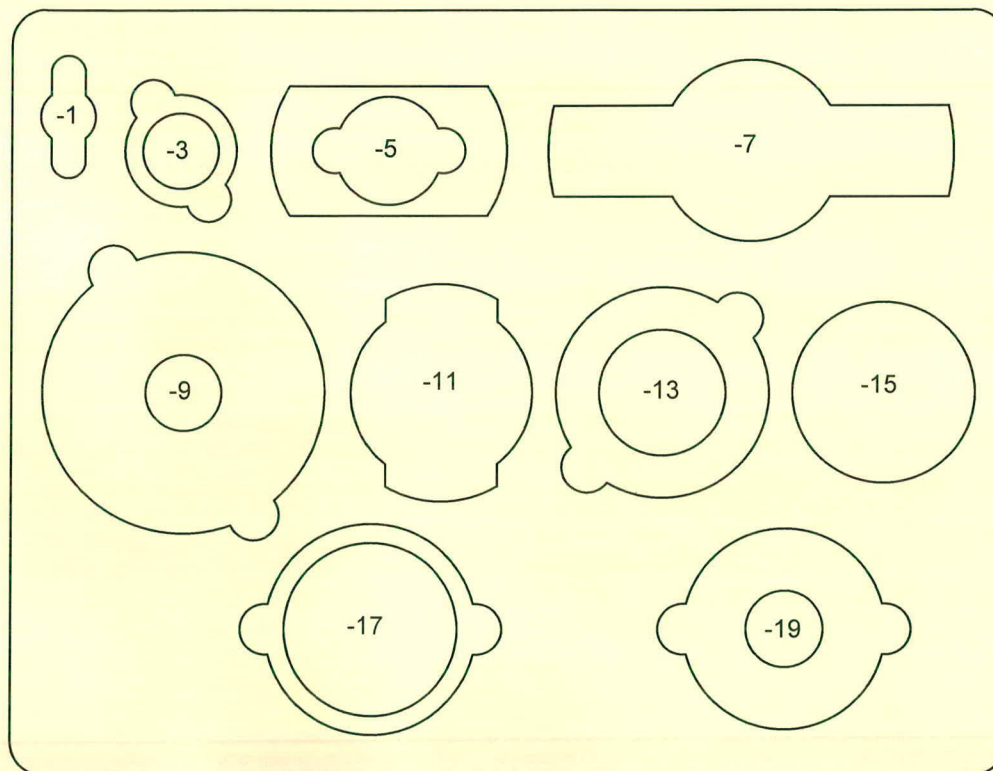
2-7-11

SHEET

1 of 6

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHD -23 FOAM DIM'S, CHD Ø4.02 DEPTH FROM 2.50 PER R.W.	3/24/11	RJC	RW
1A	CHD -23 Ø4.02 HOLE DEPTH FROM Ø3.50 & CORRECTED SIDE VIEW PER D.W. CHD Ø3.84 HOLE DEPTH FROM 7.75 & Ø4.69 HOL DEPTH FROM 3.00 TO FIT BETTER.	9/16/11	RJC	DW



 RED BARN MACHINE	
TITLE MAIN ROTOR DRIVE TOOL KIT 2	
DWG NO. RBW6305G19731-3G	REV 1C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .005 .01 .1 METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED: <i>D. Weil</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:4	DATE 2-7-11 SHEET 2 of 6

